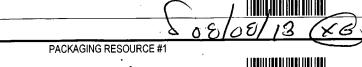
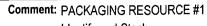
Each

Dart Aerospace Ltd. Friday, 01/08/2008 3:30:34 PM Date: Julie Lecocq User: **Process Sheet** ·: GASKET **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 40941 -: 10433 **Estimate Number** : D32555 **Part Number** P.O. Number : D3255 REV B **Drawing Number** : 01/08/2008 S.O. No. : This Issue : NC Project Number : N/A Prsht Rev. : B : // Type : PURCHASED PARTS **Drawing Revision** First Issue : 36779 Material **Previous Run** Qty: 10 Um: : 15/08/2008 **Due Date** Written By **Checked & Approved By** : Est A 04.05.12 New issue KJ/RF Comment Est Rev:B Now On Waterjet 06-08-14 JLM **Additional Product** Job Number: **Machine Or Operation:** Description: Seq. #: Gasket 1.0 D3255 Comment: Qty.: 1.6182 Each(s)/Unit Total: 16.1816 Each(s) Gasket use D3255 .063" thick silicone coated fiberglass FLOW WATER JET WATER JET 2.0 Comment: FLOW WATER JET 1-Cut as per Pwg D3255 B 8-8-13 Dwg Rev:_ Prog Rev:_ 2-Deburr if necessary INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0 QC8 SECOND CHECK





Comment: SECOND CHECK

PACKAGING :

Identify and Stock Location



Dart Aerospace Ltd

W/O:		WORK ORDER CH	WORK ORDER CHANGES				
DATE	STEP	STEP PROCEDURE CHANGE		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		· ····································			·		

NCR: 40941 WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Engl	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
હોકાર	2.0	Durkin inspection it was noticed that the mail was tocorrect. Theoriest incorrect. Theoriest operator pulled GGB, works mak	posium2	Scrop and Destry and Replace OH with cornel mat. Bly 28853 D 3255	B-E-B	8/6/13	OHUIZ	Coolore 12

NOTE: Date & initial all entries

Date: User:

Friday, 01/08/2008 3:30:34 PM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GASKET

Job Number: 40941

Part Number: D32555

Job Number:



Seq. #:

Machine Or Operation:

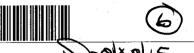
Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE





Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8.0815

Dart Aerospace Ltd

W/O:		WORK ORDER CHA	WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				•			
							:
Dort No	_	DAD #1 Fault Catamanu	NOD. V.			D-4	1

Part No:	PAR #: Fault Category: NCR: Yes No DQA: Date:
	QA: N/C Closed: Date:
NCR:	WORK ORDER NON-CONFORMANCE (NCR)

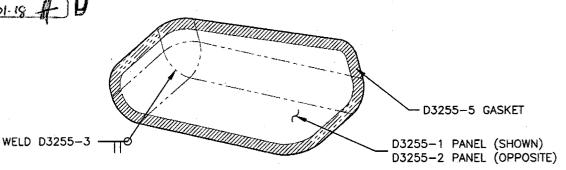
NCK.										
		Description of NC	Corrective Action Section B			Varification	A 1	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector		

NOTE: Date & initial all entries

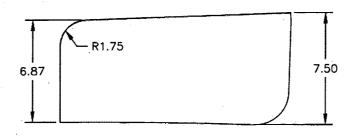


DESIG	174	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECK	ED ,	APPROVED	DRAWING NO.	REV. B
	41	#	D3255	SHEET 1 OF 4
DATE	· · · · ·	· · · · · · · · · · · · · · · · · · ·	TITLE	SCALE
04.1	2.06		ACCESS PANEL ASSEMBLY	1:6
Α		04.01.27	NEW ISSUE	

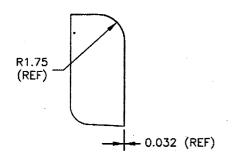
04.12.06 | D3255-3 REDESIGN; ADDED Ø0.098

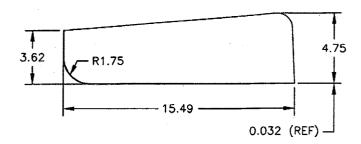


D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



В





SHOP COPY **RETURN TO** ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER

D3255-1 BEND DETAIL D3255-2 OPPOSITE

D3255-041/-042 NOTES:
1) WELD PER DART QSI 004

2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS

4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

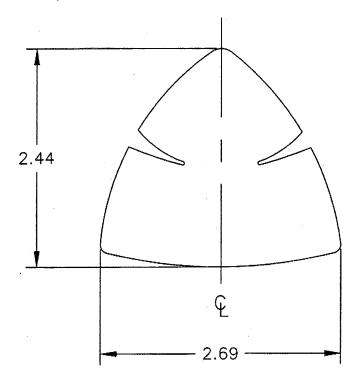
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN 72F	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. B
97	1	D3255	SHEET 2 OF 4
DATE		TITLE	SCALE
04.12.06		TITLE	. 1:1

RELEASED



D3255-3 CAP FORM TO FIT D3155-1/-2

SHOP COP

RETURN TO

ENGINEERING

1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)

UNCONTROLLED COPY

2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED SUBJECT TO AMENIMENT

WITHOUT NOTICE

3) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

6) MAKE PER DRAWING "D3255-B2.DWG"

D3255-3 NOTES:

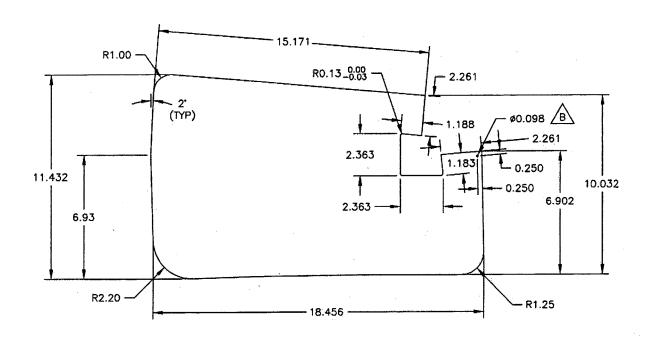
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	DRAWING NO.	REV. B
4	1	D3255	SHEET 3 OF 4
DATE	<u> </u>	TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5

RELEASED



D3255-1/-2 FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

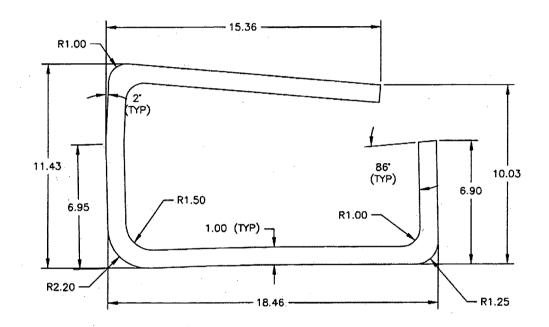
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CA	
CHECKED	APPROVED	DRAWING NO.	REV. B
4'	T	D3255	SHEET 4 OF 4
DATE		TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5





D3255-5 GASKET

D3255-5 NOTES:

1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

-DART AEROSPACE LTD	Work Order:	40941
Description: GASKET	Part Number:	D3982-2
Inspection Dwg: \(\) \(\) \(\) \(\) Rev: \(\)		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	4030	,996,	<u>}</u>			
18.46	4030	18,40	x			
11.43	4 20	11.43	*			
15.36	7030	15,36	*			
6.90	1/2 .030	6,90	مط			
.063	400	, 663	x			
						: /
	·					
						···
			,		-	
					,	

			\triangle				
Measured by:	IB.	Audited by:	9	/		Prototype Approval:	1
Date:	8-8-3	Date:	081	081	13	Date:	b

Re	v	Date	Change	Revised by	Approved
A			New Issue	KJ/JLM	